

Date: Wednesday, 25/06/2008 11:59:09 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	205 BEARPAW INSTALLATION KIT (48")
Job Number :	40082		
Estimate Number :	12283		
P.O. Number :		Part Number :	D205564011
This Issue :	25/06/2008	Drawing Number :	D2521
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	J
Previous Run :	38806	Material :	
Written By :		Due Date :	09/07/2008
Checked & Approved By :	JLD 08.6.25	Qty:	4 Um: Each
Comment :	Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM Est Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

See 1/7/37 #

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING

Program Batch Number

See 08.06.27

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 13.6500 sf(s)/Unit Total : 54.6000 sf(s)

blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6

Material: Black UHMW 1"

(MUHMWB10)

Batch: M108643

Y.A

08/07/29

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

SD / Y.A

08/07/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 11:59:09 AM
User: Julie.Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 40082

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD / H.A

08/07/29

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 08/07/30

(4)

7.0

D2182B

Rubber Cushion



Comment: Qty.: 3.7000 f(s)/Unit Total: 14.8000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion

B39986

B30872

sp

8.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block

(16)

B38173

64
B39239

sp

9.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer

B38188

sp

10.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp

X (1)

B32859

(31)

B36826

8/1/30

sp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 11:59:09 AM
User: Julie.Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 40082

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3544041

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
CLAMP
Batch: B36760 (B) 500836 (B)

12.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)
Bolt
Batch: M104909

13.0

AN415A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total: 80.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
20 AN4-15A Bolt 108077

14.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 80.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
20 AN960JD416 Washer M107939

15.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total: 80.0000 Each(s)
Nut
Batch: M107478

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 11:59:09 AM
User: Julie, Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 40082

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Loc 23



(4R)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 

8/7/31

SL

18.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

208/05/08

Job Completion



MF 08-08-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40082
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	✓			
B	0.90	0.96	0.927	✓			
C	0.27	0.330	0.298	✓			
D	0.470	0.530	0.500	✓			
E	21.740	21.760	21.760	✓		tape	
F	0.72	0.780	0.752	✓			
G	0.35	0.410	0.378	✓			
H	11.490	11.570	11.490	✓		tape	
I	3.41	3.47	3.418	✓			
J	11.790	11.810	11.808	✓			
K	9.47	9.53	9.50	✓			
L	7.190	7.210	7.1987	✓			
M	6.910	6.970	6.937	✓			
N	44.47	44.530	44.470	✓		tape	
O	6.590	6.650	6.620	✓			
P	0.940	0.980	0.958	✓			
Q	18.97	19.03	19.000	✓			
R	0.350	0.410	0.379	✓			
S	0.740	0.780	0.752	✓			
T	0.240	0.280	0.253	✓			
U	0.370	0.410	0.404	✓			
V	0.740	0.780	0.768	✓			
W	0.740	0.780	0.763	✓			

Measured by: M.A	Audited by: <i>ML</i>	Prototype Approval:	N/A
Date: 08/07/29	Date: 08/07/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM <i>JA</i>	<i>JA</i>



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

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WITHOUT NOTICE
WORK ORDER
NO. 40082

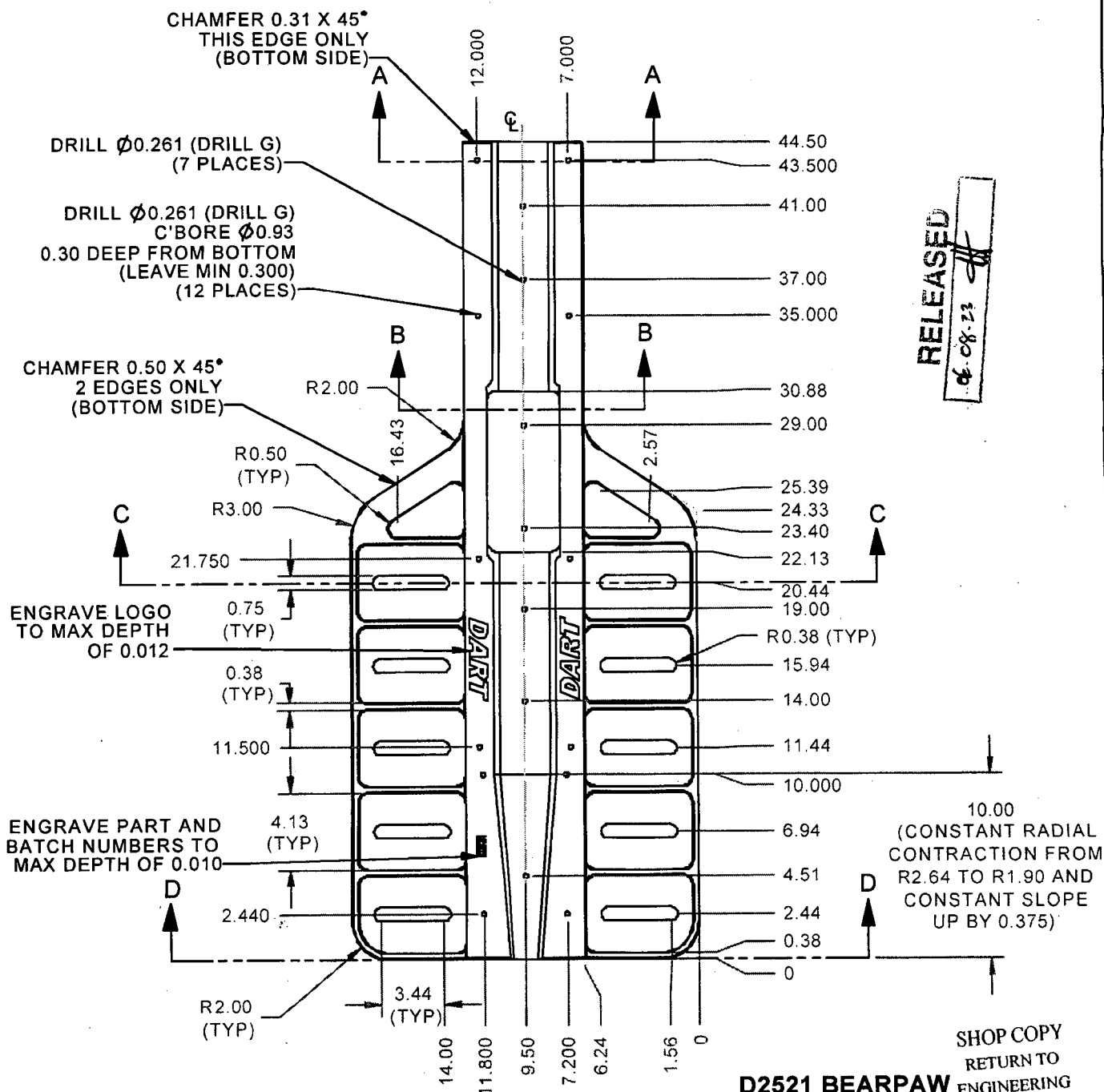
RELEASED
06.08.23 #

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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D2521	REV. J SHEET 2 OF 3
DATE 06.07.28	TITLE 205 BEARPAW	SCALE 1:8	

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT \varnothing

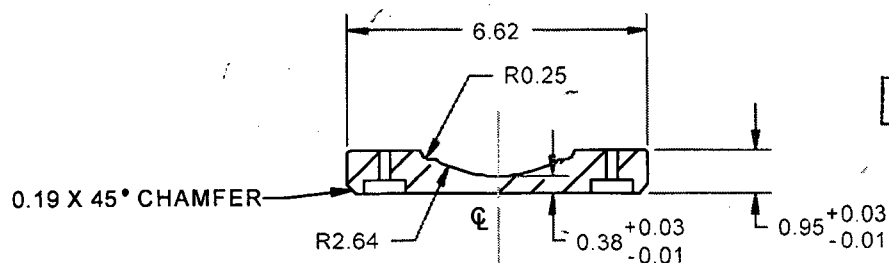
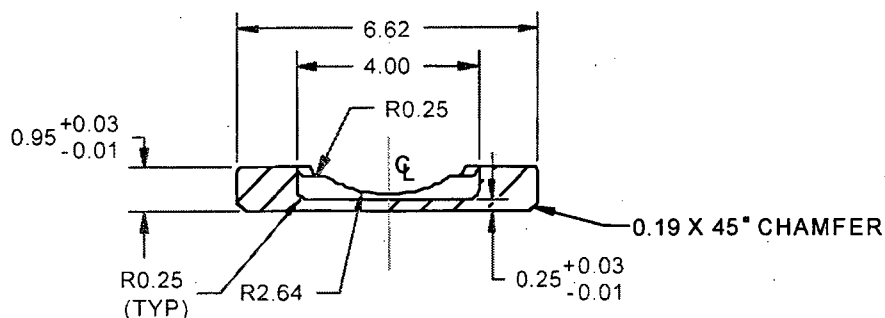
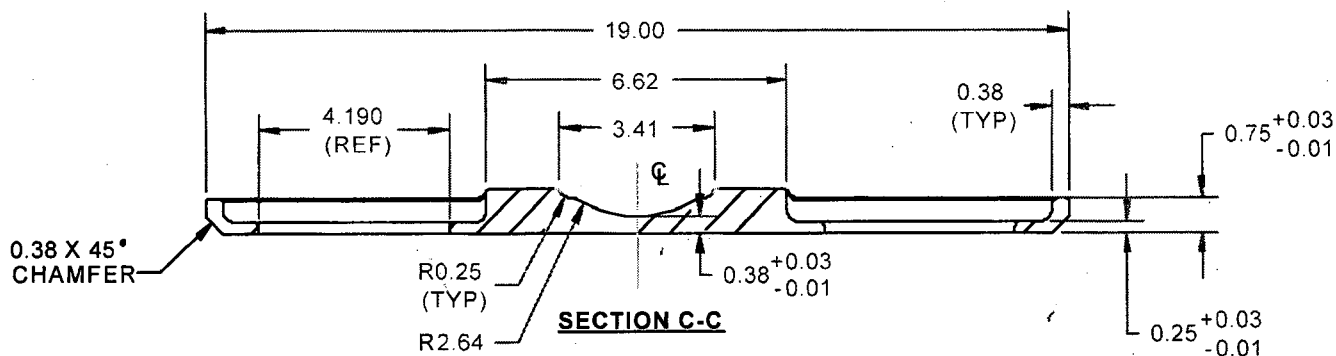
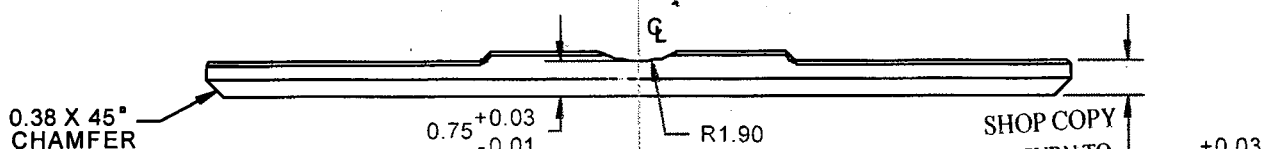
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D2521 BEARPAW
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BY NOTICE
ORDER
No. **40080**

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28	TITLE 205 BEARPAW	SCALE 1:4	

**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

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 User: Julie Lecocq

Process Sheet

28

Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : 205 BEARPAW INSTALLATION KIT (48")
Job Number : 40082
Estimate Number : 12283
P.O. Number : **Part Number** : D205564011
This Issue : 25/06/2008 **S.O. No.** : **Drawing Number** : D2521
Prsht Rev. : NC **Project Number** : N/A
First Issue : / / **Type** : MACHINED PARTS **Drawing Revision** : J
Previous Run : 38806 **Material** :
Written By : **Due Date** : 09/07/2008 **Qty:** 4 **Um:** Each
Checked & Approved By : JLD 08.6.25
Comment : Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC
 Est Rev:G 06-08-28 As per Rev E JLM
 Est Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



JLD 08.6.24

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

2.0

MFG ENGINEERING

MFG ENGINEERING

**Comment:** MFG ENGINEERING

Program Batch Number

3.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 13.6500 sf(s)/Unit Total : 54.6000 sf(s)
 blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: _____

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr